

Date: Tuesday, 10/23/2007 3:10:27 PM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 35322	
Estimate Number : 12425	
P.O. Number :	Part Number : D2000111
This Issue : 10/23/2007 S.O. No. :	Drawing Number : D2000-111 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 27332	Material :
Written By :	Due Date : 11/15/2007 Qty: 10 Um: Each
Checked & Approved By : <u>07.10.23</u>	
Comment : Est Rev.A New Issue 06-05-31 JLM	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 4888 For D2000-111

Spin as per Dwg D2000-111

Possible Supplier: SIEG

Material release note is required

07/10/24



2.0	D2000111S	Aspirator - Inner Core
-----	-----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aspirator - Inner Core

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

7/11/07

SC 10X

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

08-05-06



5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2000

Deburr

FF 08-05-21



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-19	1.0	Upon inspection, the parts were found to be non-conforming to the drawing. O.D. is too small, and I.D. is too large.	08/04/19	<del>Return for replacement as per DCB 250</del> Not necessary, Making parts i Assy is A1			08/04/19	07-11-19

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 35322

Part Number: D2000111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/05/21 @

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 162

8/5/21

10x

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



MF 08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

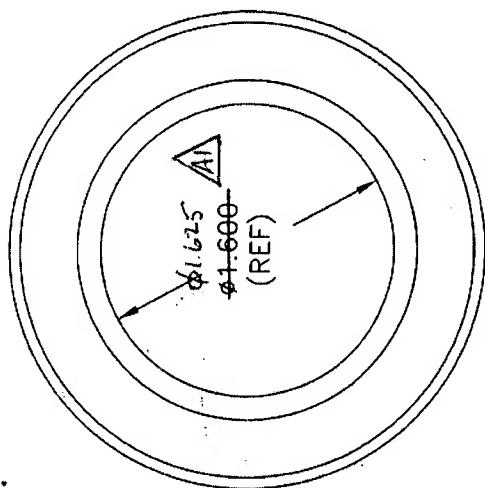
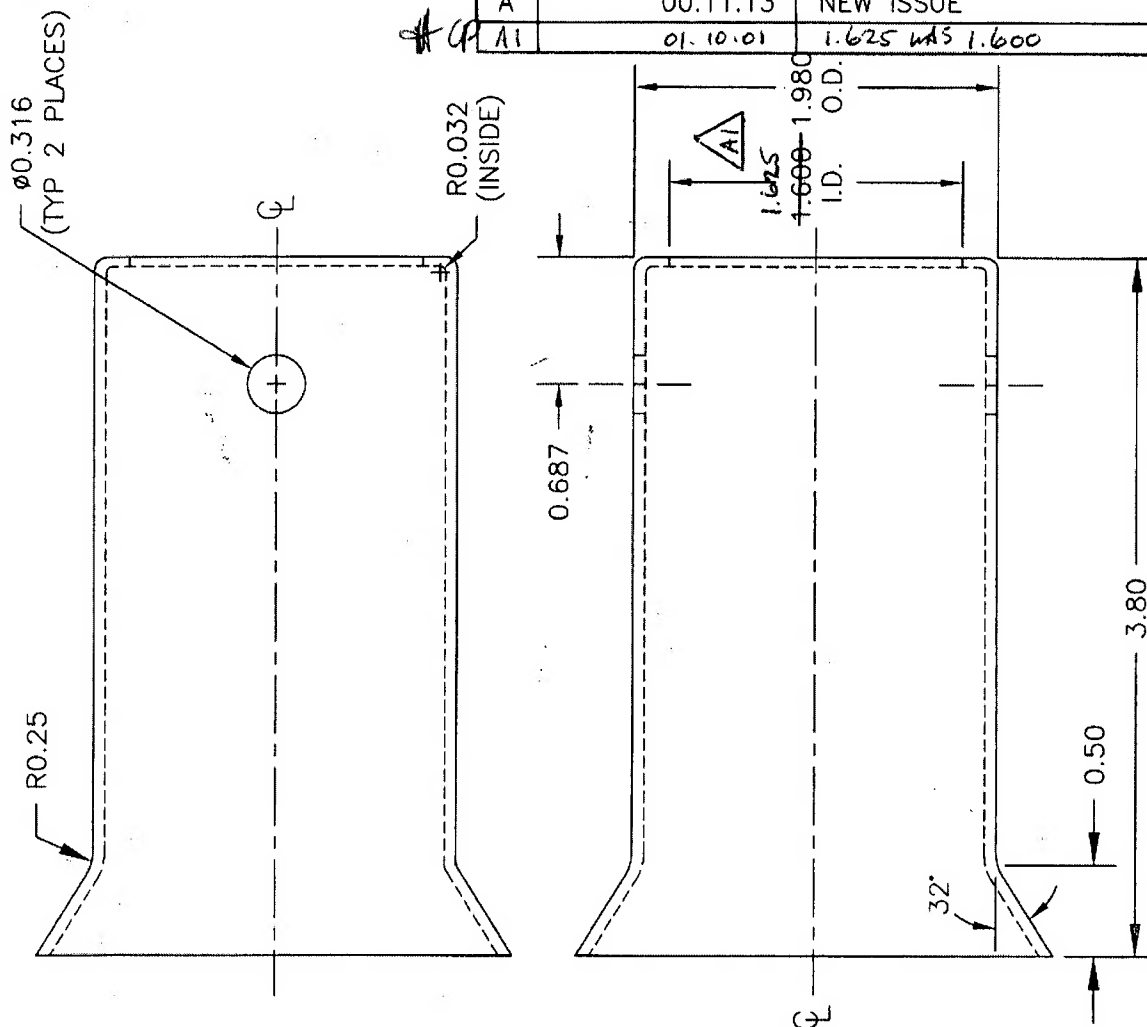
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2000-111	REV. A SHEET 1 OF 1
DATE	00.11.13			TITLE ASPIRATOR	SCALE 1:1
A	00.11.13			NEW ISSUE	
AI	01.10.01			1.625 WAS 1.600	



RELEASED

00.11.20

FOR COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35322

NOTES:

THIS PART MUST MATE WITH D2000-109  
MATERIAL: 1100-0 ALUMINUM (QQ-A-250/1) 0.063 THICK  
FINISH: NONE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



W.H. GERRY



ALCOA INERT PRODUCTS  
1480 Manheim Pike  
Lancaster Pa 17601

# Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 1000875996

DATE 4/23/2007

SKID NO 661032

SKID WGT 9,885

PAGE 1 OF 1

10 12:52 FAX

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH
ITEM NO	1	PART NO				NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GUAGE	05300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 334171 COIL: B01 DROP: 07TG187

INGOT	SI	FE	CU	NI	MG	CR	NI	ZN	TI
0718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI  
TAIL ULTIMATE STRENGTH 12.0 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI  
HEAD ELONGATION (G.L. = 2 IN) 32 %  
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-05

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
ASME SB022 1100 C, AMS 4001H 1100 C,  
ASTM B209-05 1100 O, AMS-QQ-A 250/1 1100 O  
PAX CERTS- 714-736-4040

\*\* END OF CERTIFICATION \*\*

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material and the composition, if any, have been examined and a correct certification in aluminum alloys and neither in any of its components are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

For use in quality management and control systems representing the product and service provided by the company. Exportation of this report is prohibited. Reproduction of this report is prohibited.

Authorized By: JEFF KROBAY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature

0001-001



**Sieg's Manufacturing Ltd.**

**Metal Spinning and Fabricating**

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: Nov. 5/07

Customer: Dart Aerospace

Packing Slip: 34575

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	n/a	✓	<del>HR</del>
D2000111S	10	14G	n/a	✓	<del>HR</del>

7/11/07

SG Notes:

2 Boxes.

Material Certification Attached: yes

REFERENCE C



Sieg's Manufacturing Ltd.  
6236 205 street, Langley BC, V2Y 1N7  
Phone: (604) 530-7455 Fax: (604) 530-7490

## Packing Slip

Packing Slip No.: 34575  
Date: 11/05/2007  
Page: 1

<b>Sold to:</b>		<b>Ship to:</b>	
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
<b>Order No.:</b>	4888	<b>Sold By:</b>	KAULBARS, GERRY
<b>Shipped By:</b>		<b>Ship Date:</b>	11/06/2007
<b>Tracking No.:</b>			

Item No.	Unit	Description	Quantity
1	EACH	D2000109S OUTER FLANGE	
2	EACH	D2000111S INNER CORE ..	
REFERENCE ONLY			
Comment:			